

Work Order ID 75420

Friday, October 21, 2011 2:21:15 PM

75420

Page 1

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 10/21/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/2/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 11/10/21

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Required Date: 11/2/2011 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
F10 *110*	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804								
	3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. Pick: Qty Part Number Description Batch A/R Aluminum Rod M117889								
	4-Grind weld flush to cap on top surface only.								
	5-Cut Aft end as per dwg D3804 from front of tube and Deburr								
	6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804.								
	7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.								
	8-Drill pilot holes using Dt8166 & DT8169D & DT9771.								
	9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.								
	10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.								

SAD - 11-11-24
 BE 11-11-25
 BB 11/11/25
 DE 11/11/28

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 Required Date: 11/2/2011 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
 ****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

DC
 11/11/28

11 - 11 - 28 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start *NS1*

Stop *NS2*

Start Date: 10/21/2011 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 11/2/2011 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Chemical Conversion Coat per QSI005 4.1

0.00

140

0.00

HandFinish

Memo

Hand Finishing

150

QC3- Inspect Part Finish

0.00

150

0.00

QC

Memo

Quality Control

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

OK
4/4/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Start Date: 10/21/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/2/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC6- Inspect dimensions to drawing	0.00							
170									
QC	Memo	0.00							
Quality Control									
180		0.00							
180									
Skidtubes	Memo	0.00							
Skidtubes	1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required								
	2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting								
	Start Date: 11/11/28 Time: 8:35								
	Finish Date: 11/11/29 Time: 10:00								
	Pick:								
	Qty Part Number Description Batch								
	A/RSikaflex-291 119399								
	Sikaflex expire date: 12/08/13								

DE
11/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

190

QC

Memo

0.00

Quality Control

1 0 BEA-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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 Start Date: 10/21/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/2/2011 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200		0.00							
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200

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch
 A/RAluminum Rod M117889

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE BE 11-11-29

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 11-11-29

B 11/11/29

DP

11-11-30

W/O:		WORK ORDER CHANGES					
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Start Date: 10/21/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/2/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

210

HandFinish

Hand Finishing

HandFinishing

Memo

Install D2680-041 Nut Plate as per Dwg D3804

0.00

0.00

215

215

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

220

220

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Start Date: 10/21/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/2/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>[Signature]</i>	<i>11</i>	<i>12</i>	<i>01</i> <i>(1)</i>
240 *240* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							<i>[Signature]</i> <i>11/12/01</i>
250 *250* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00							<i>[Signature]</i> <i>11/12/05</i>

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

8-30
320 OF
9:00

M118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 75420***75420***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, October 21, 2011 2:21:15 PM

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N900040100

Setup Start *NS1*

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Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

0.00

280

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 1119443

Sikaflex expire date: 12/01

2- Install wearplate as per dwg

2-Wing Walk as per Dwg.D3804 and QSI 005 4.4

Batch: 111898

290

QC3- Inspect Part Finish

0.00

290

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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300	QC5- Inspect part completeness to step on W/O	0.00							
300		0.00							
QC	Memo								
Quality Control									
310		0.00							
310	Packaging	0.00							
Packaging	Memo								
Packaging	Identify and pack for shipping as per PPP D206-642-151								
	Location: _____								
	PPP Rev: _____								
320	QC21- Final Inspection - Work Order Release	0.00							
320		0.00							
QC	Memo								
Quality Control									

R11-12-14

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 75420

75420

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10:12:08 PER IIN REV:N DD VERF:EC IPP
REV:B 11:09:16 PER IIN REV:O DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2620

Manufactured

No

110

Each

13.0000

1

1

D2620

Skidtube, 206 Skidtube

**

SAD 11-17-24

Location

Loc Qty

Loc Code

LG

13

71616

3

71617

6

73783

1

73785

1

73786

2

75469

D2647

Manufactured

No

110

Each

197.0000

1

1

D2647

Cap

**

BEI-11-25

Location

Loc Qty

Loc Code

LG002

197

55352

4

71171

10

73826

183

1

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

18,861.00

52

52

CR3212-4-04

Cherry Rivet

**

Location

Loc Qty

Loc Code

ST311

150

116471

78

117816

3

118686

1

118840

68

st510

10000

119075

10000

ST516

8711

119017

8711

D2654-1

Manufactured

No

180

Each

3.0000

1

1

D2654-1

Web

**

Location

Loc Qty

Loc Code

LG

3

73794

3

D3286-1

Manufactured

No

180

Each

108.0000

2

2

D3286-1

Doubler

**

Location

Loc Qty

Loc Code

LG002

108

74111

20

74441

88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 21, 2011 2:21:20 PM

Work Order ID: 75420

75420

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 200 Each 1,146.000 19 19

D2649

Cross Bolt Spacer

BE11-11-29

B 73859 ~19

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	617	
68224	2	
71355	2	
72704	2	
72841	11	
73855	600	
LG001	529	
65317	1	
68507	11	
73390	8	
73857	21	
73860	488	

D3286-3 Manufactured No 200 Each 97.0000 2 2

D3286-3

Spacer

BE11-11-29

B 74870 ~2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	97	
74117	17	
74439	80	

D2680-041 Manufactured No 210 Each 99.0000 1 1

D2680-041

Nut Plate

(1)

Bu/11/30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	4	
73334	4	
ST020	95	
73854	95	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 75420

75420

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

210

Each

2,010.000

2

CR3212-4-03

Cherry Rivet

**

2

B u / u / 30

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1008

114859

1008

ST318

1000

119017

1000

AN960JD416

NAS1149D0463J

Purchased

No

210

Each

0.0000

1

AN960JD416

Washer

**

M 11838 4 (v) M u l i z l r

CCR264SS3-3

Purchased

No

210

Each

1,285.000

2

CCR264SS3-3

Cherry Rivet

**

2

B u / u / 30

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

283

117849

283

ST317

1000

119017

1000

MS27039-4-06

Purchased

No

210

Each

433.0000

1

MS27039-4-06

Screw

**

u

u l i z l r

Location

Loc Qty

Loc Code

ST292

433

119075

400

119124

33

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, October 21, 2011 2:21:20 PM

Work Order ID: 75420

75420

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No

270 Each

1,063.000 6

6

D2651-1

Plug

**

Handwritten: 11/12/12

Location

Loc Qty

Loc Code

fpa

2

69018

2

FP-A

1061

57869

1

66445

10

70839

2

71037

31

73827

1017

Handwritten: X 6

D2651-3 Manufactured No

270 Each

1,547.000 6

6

D2651-3

O-Ring

**

Handwritten: 11/12/12

Location

Loc Qty

Loc Code

FP-A

1547

61962

12

66956

30

73489

505

73828

1000

Handwritten: X 1

Handwritten: X 5

D3873-1 Manufactured No

280 Each

342.0000 14

14

D3873-1

Bushing

**

Handwritten: 1373832 (x 14) 11/12/12

Location

Loc Qty

Loc Code

ST088

342

64760

1

68247

4

73829

19

73831

318

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, October 21, 2011 2:21:20 PM

Work Order ID: 75420

75420

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280

Each

91.0000

1

1

D2646

Aft Cap

**

B73825 (v1) JH 11/12/12

Location

Loc Qty

Loc Code

FP002

60

73294

60

FP004

17

68280

17

FP006

5

62678

5

FP-4

5

70945

1

71070

4

fp5

4

71038

4

D3805-041

Manufactured No

280

Each

0.0000

1

1

D3805-041

Wearplate Assembly Fwd, Low Gear

MS27039-1-08

Purchased No

280

Each

1,971.000

2

2

MS27039-1-08

Screw

**

B75-486 (v1) JH 11/12/12

**

JH 11/12/12

Location

Loc Qty

Loc Code

ST291

1971

117423

155

118378

316

118910

500

119075

500

119109

500

x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 7

Friday, October 21, 2011 2:21:20 PM

Work Order ID: 75420

75420

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

280

Each

9,976.000

7

7

MS21042L3

**

M 11/12/12

Nut

Location

Loc Qty

Loc Code

ST300

976

117441

16

117885

87

118451

179

118927

694

ST516

6000

119017

6000

ST518

3000

119075

3000

v7

D3805-045

Manufactured

No

280

Each

5.0000

1

1

D3805-045

**

1375494 (x1) M 11/12/12-

Wearplate Assembly Aft, Low Gear

Location

Loc Qty

Loc Code

FP

5

73817

5

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

AN960JD10L

**

1118389 (x2) M 11/12/12

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Friday, October 21, 2011 2:21:20 PM

Work Order ID: 75420

75420

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2011

Required Date: 11/2/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No

280 Each 2,319.000 7 7

AN3-37A

Bolt

** 11/12/12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST353	269	
111668	169	
118628	100	
ST354	50	
117619	50	
ST518	2000	
<u>119086</u>	2000	

17

NAS1149D0363J Purchased No

280 Each 2,836.000 7 7

NAS1149D0363.J

Washer

** 11/12/12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	2836	
117601	218	
118077	135	
118612	483	
<u>118968</u>	2000	

17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

75420 NO 11-10-21
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

RELEASED
 09.03.03
 per ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 1 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

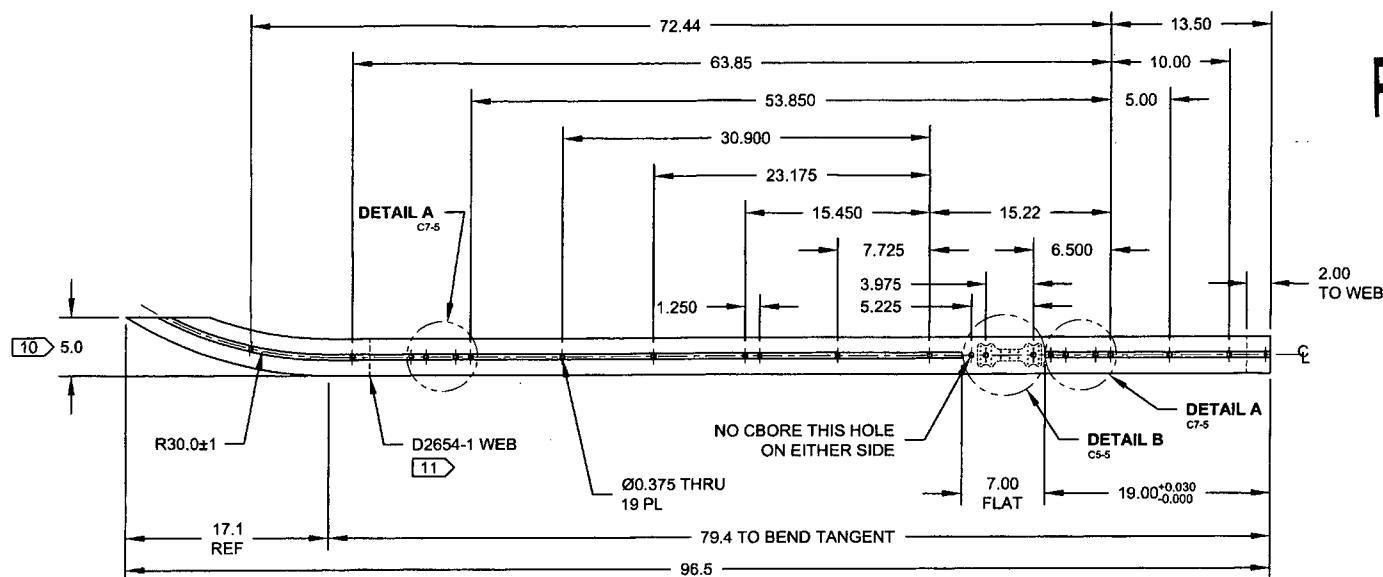
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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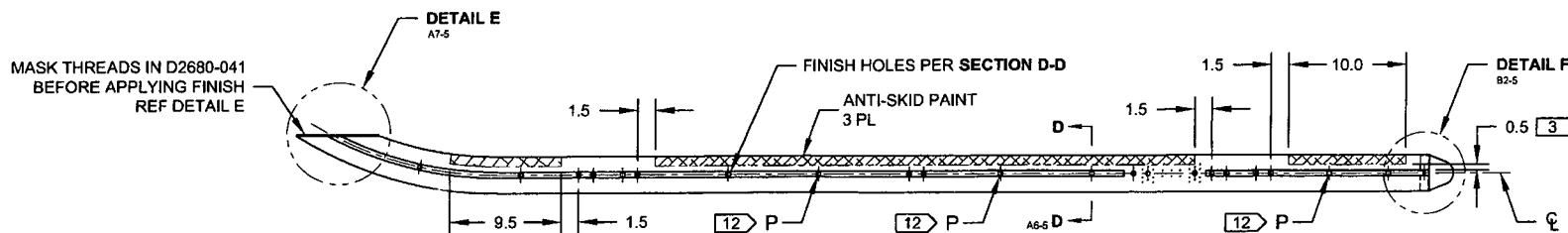
NOTE: Date & initial all entries

75420

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 2 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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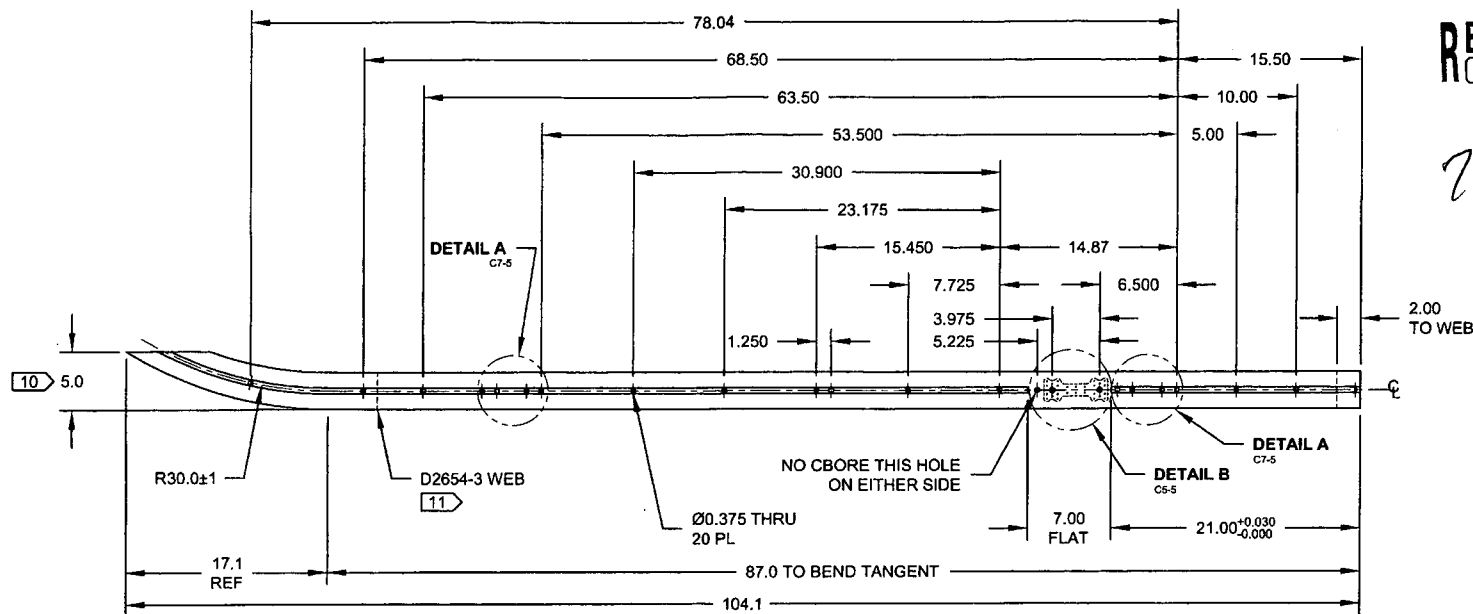
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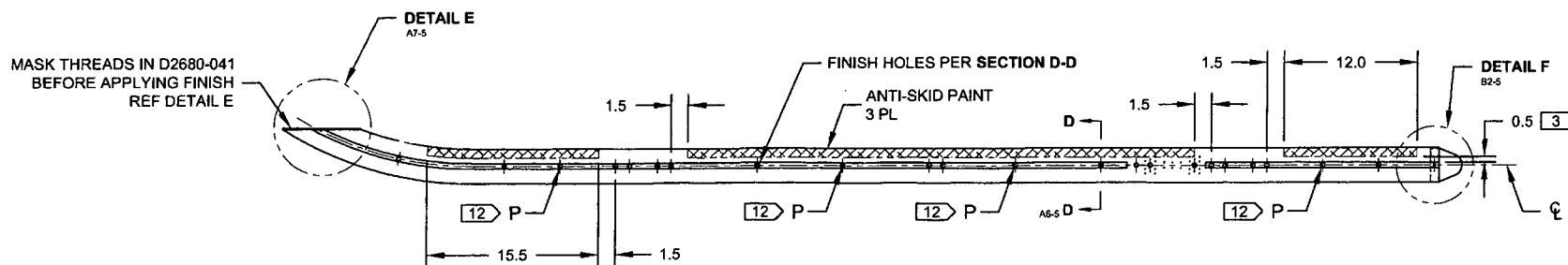
NOTE: Date & initial all entries

RELEASED
09-03-03

75420



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
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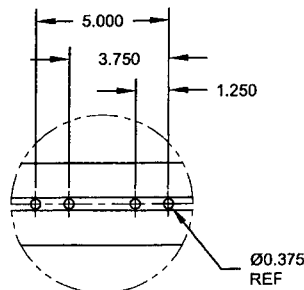
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

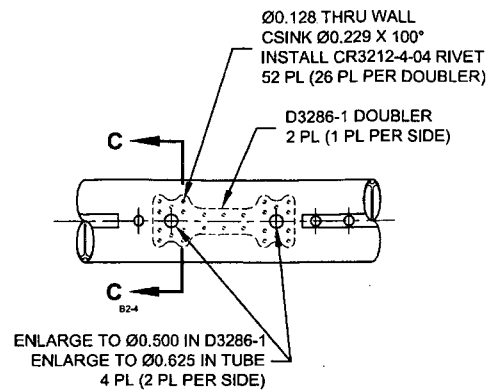
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

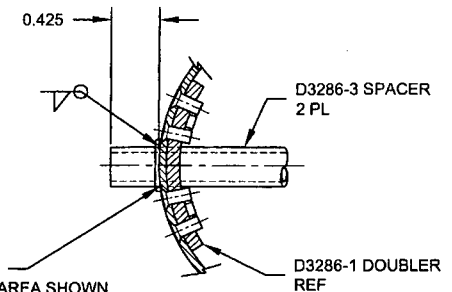


DETAIL A
D6-2
C2-2
D6-3
C2-3
SCALE NONE



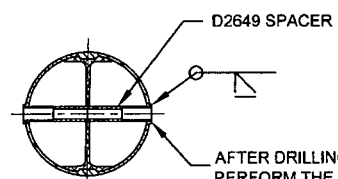
DETAIL B
C3-2
C3-3
SCALE NONE

75420



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
C6-4
PARTIAL SECTION
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 4 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	H	SKIDTUBE ASSEMBLY, 206A/B	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

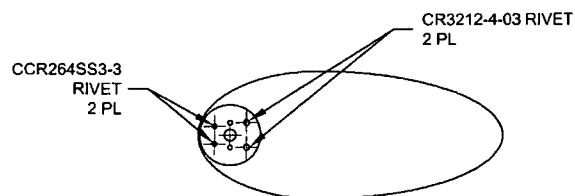
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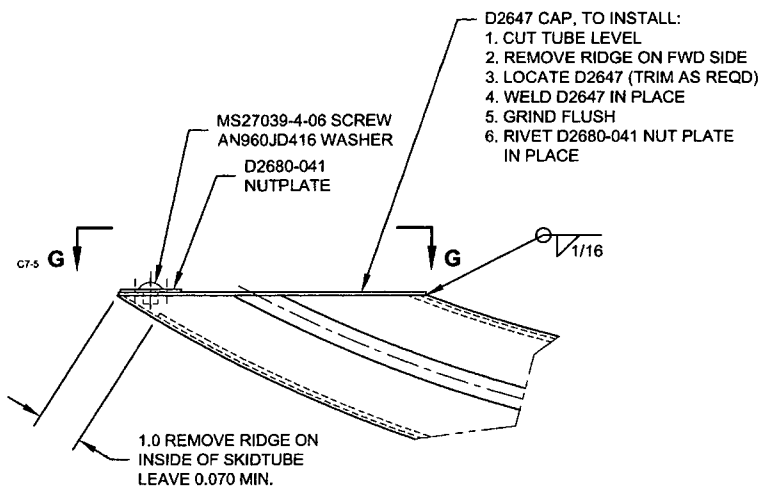
NOTE: Date & initial all entries

RELEASED
97 07 03 03

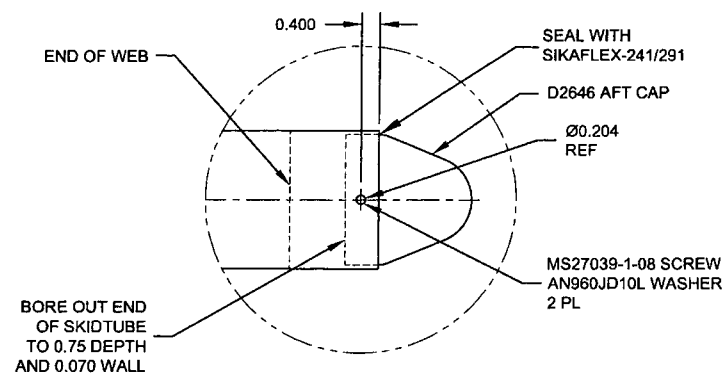
75420



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 5 OF 5
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